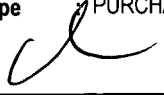


Date: Monday, 15/12/2008 7:38:14 AM
 User: Chantal Lavoie

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STEP EXTRUSION |
| Job Number : | 44064 | | |
| Estimate Number : | 10058 | | |
| P.O. Number : | | Part Number : | D2622120C |
| This Issue : | 15/12/2008 | Drawing Number : | D2622 REV C1 |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | // | Drawing Revision : | C1 |
| Previous Run : | 42155 | Material : | |
| Written By : |  | Due Date : | 26/01/2009 |
| Checked & Approved By : | C208112/15 | Qty: | 120 |
| Comment : | Est. A: 02.11.12 New Issue KJ/RF | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 7827

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C208112/15

(120)

2.0 D2622120CP

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)
 Extrusion

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

SS 09/01/21

(126)

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622
 Check Pull test per Dwg D2622 for compliance page attached
 Check hardness with Webster tester

J 05-01-23

70
+30
+6

(126)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 15/12/2008 7:38:15 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 44064

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W A

SAD 09-01-26

X 70

56

(126)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 J

Job Completion



U 09.01.26

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

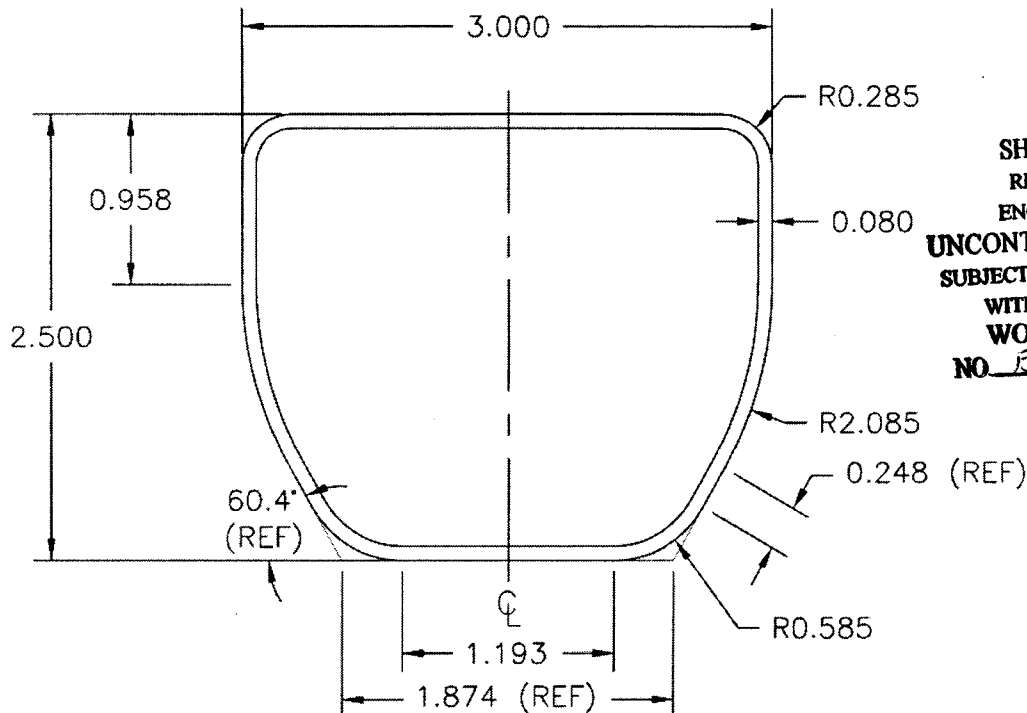
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN KE | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2622 | REV. C SHEET 1 OF 1 |
| DATE 02.09.11 | | TITLE STEP EXTRUSION | SCALE 1:1 |
| A | 96.11.29 | NEW ISSUE | |
| B | 97.12.12 | CHANGE MATERIAL, ADD TOL. QSI | |
| C | 02.09.11 | 0.080 WAS 0.085; ADD PART & DIE No. | |
| CI | CP 02.10.04 | ADD 'REV-A' TO DIE NUMBER | |

RELEASED
02-09-11 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 344064

D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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ACCT# 00046024

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

MANIFEST DATE
01-19-09MANIFEST NUMBER
653432SALES ORDER NUMBER
41450REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCECREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNSOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

PHONE 613-632-5200

TERMS / FREIGHT
O / PCUSTOMER ID
46024ORDER DATE
12/15/08CUSTOMER PO NUMBER
7827

JOB

BILL OF LADING NUMBER
08387743

| ITEM NO. | ORIGINAL ORDER QUANTITY | UNIT | PREVIOUS SHIPPED QUANTITY | MFG. PART NUMBER | ALLOY & TEMPER | FINISH DESCRIPTION | THIS SHIPMENT | | | UNIT | QUANTITY DUE | |
|----------|-------------------------|------|---------------------------|----------------------|-----------------------------------|-------------------------|---------------|--------------|--------------|------|--------------|--|
| | | | | CUSTOMER PART NUMBER | LENGTH | FABRICATION DESCRIPTION | NBR OF PKGS | GROSS POUNDS | NET QUANTITY | | | |
| | | | | | CUTTING TOLERANCE | SHIPPING TOLERANCE | | | | | | |
| 01 | 121 | KG | 0 | DAA-897123-1 | 6061 /T6 | MILL | 2 | 551 | 531 | KG | | |
| | | M | 0 | D2622 | 120" | CERTIFICATE OF COMP | | | 384.05 | M | | |
| | | PC | 0 | | +3/16 " | (+015-015,0139-0102) | | | 126 | PC | | |
| | | | | | -0 " | | | | | | | |
| | | | | | *****PLEASE - DO NOT PRESHIP***** | | | | | | | |
| | | | | LOT/TKT DETAIL: | | 41450010 / 203279 | 1 | 305 | 295 | | 70 E | |
| | | | | | | 41450010 / 203280 | 1 | 246 | 236 | | 56 E | |
| | | | | | | | 2 | 551 | 531 | KG | | |
| | | | | | | | | | 384.05 | M | | |
| | | | | | | | | | 126 | PC | | |
| | | | | | | | TOTALS | | | | | |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE

1

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PAGE 1

EXTMAN? CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

| Cert Date | Cert No | Sales Order | Page |
|-----------|----------|-------------|---------|
| 01/19/09 | 186225 | 41450 | 1 |
| Cust PO | B/L No | Lot | Date |
| 7827 | 08387743 | 41450010 | 1/19/09 |

| Sold To | Ship To |
|--|--|
| DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No | Part No | Item Description | Cust Part |
|---------|--------------|-------------------|-----------|
| 1.000 | DAA-897123-1 | 120" Mill 6061 T6 | D2622 |

| Gross Weight | 551 KGS |
|--------------|---------|
|--------------|---------|

| Net Qty | 531 KG | 126 PC | 384 M | 2 PKG |
|---------|--------|--------|-------|-------|
|---------|--------|--------|-------|-------|

| Specification | Die Desc |
|-------------------------------|----------|
| AMS-QQ-A-200/8 & ASTM B221-08 | |

Mechanical Tests:

| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/ Drift HREW |
|----------|-------------------|-----------------|-------------|--------------|------------------|
| 1 | 316.6 / 45.9 | 278.7 / 40.4 | 11.5 | .0 | 93 |

Chemical Analysis:

| SI | FE | CU | MN | MG | CR | NI | ZN | GA | V | TI | ZR | OTHER |
|-----|-----|-----|-----|-----|-----|------|-----|------|------|-----|------|-------|
| .59 | .22 | .21 | .05 | .86 | .06 | .000 | .02 | .000 | .000 | .02 | .000 | .00 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc

